<b>Work Orde</b> July-09-13 12:50					*1	043	65*							Page	1,
Revision ID:	D4016-3				Accept	*	N900	040	100	)*	Setup		I VI -	S1*	
	Hinge Ha 7/09/13		ty: 20.00	*20*			Cust Item	ID•				Stop	*N:	S2*	
Required Date:		_	ty: 20.00	*20*			Customer:								
Reference: Approvals:	Process QC:	s Plan: M	_J	Date: \(\frac{13-07-1\}{}\)	Tooling: SPC (Y/N)	:		)ate:			Run	Start Stop	1/1	R1* R2*	
Sequence ID/ Work Center ID	)	Operation Descript			Set Up/ Run Ho	ours	Tool ID	Tool #	Pian Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp	
Draw Nbr		Revision Nbr												. , ;	
D4016		A												·	
*100 *100* Bandsaw		Cut blanks	as per folio  Memo		0.00				6	20				1/3-7	-2
Jeaspa Bandsaw			CUT BLANK	C as per folio										:	
110					0.00										
*110* HAAS 1			Mana		0.00	FC	2013-0	7-24		20		Φ			_
HAAS CNC vertical	machine #	·1	Memo MACHINE A FOLIO REV DWG REV:	AS PER FOLIO FA874 AI									is .		

DEBURR

DQA:		_ Date:			•								137	TRAAC
QA Closed:		Date:			WORK ORDER NON-	-C(	ONFO	RMANCE / UI		ا ما ما ا	. O-d	-d-t [	_	AEROSPACE
QA Closed.	:	Date.				_				vvork	. Order up	odate only	Ш_	
Work Orde	er:				DISPOSITION				AGAINST [	DEPA	RTMENT	/PROCESS		
					Rework			Skid-tube	Crosstube			Water Jet	$\neg$ $_{E}$	ingineering
Part N	lo.				Scrap		,	Machining	Small Fab		Pro	d. Eng. Coor.	7	Quality
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NCR N	lo				Suspected Unapproved			Large Fab	Composite			Supplier		
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Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descr	iption	$\bot$	Date	Verification		QC Inspector
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Landir	ng Gear	-	·····		General									
	Bending				Bend		Folio/P	rogram		Tou	utside Dim	ensions [	$\neg_{Pr\epsilon}$	essure/Forced
ĺ	Centre N	ot Concer	ntric		BOM/Route	Г	Grain	J	F	_	ver/Under			t-up
	Cracks				Broken/Damage/Defect		Hardwa	re	. [		art Incorrec	<b>-</b>	_	nperature/Cure
	Crimp/Ki	nk/Ripple	/Wave		Burrs		Inspecti	ion Incomplete/Un	nqualified	Pa	art Lost/Mi	ssing	T we	·
	Cuffs				Contamination		Instruct	ions Incomplete/L	Inclear	Pa	art Moved		¬wr	ong Stock Pulled
	Crushing				Countersink		1	ned/off center		Po	sitioned W		_	-
	Heat Tre	at			Cut Too Short		Mislabe	eled		Po	wer Loss/	Surge	Oth	ner
	Inspectio	n Strip in	Tube		Drawing		Misread	i	_					
	Marks/Cl	hatter			Drill Holes		Off-set							**
ļ	Turning S	Sequence			Finish		Out of 0	Calibration						
	Wave/Tv	vist in Tub	oe .		Fit/Function		Out of 9	Sequence						

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Work Orde July-09-13 12:5	•	4365		*10	436!	<b>5</b> *						Page	2
Revision ID:	D4016-3 Hinge Half, Li	d		Accept	*N9	900	<b>04</b> 0	100	)* s	Setup Start	I VI	S1* S2*	-
. <b>[ [</b> ]	7/09/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*			st Item I stomer:	D:						
Approvals:		n:	Date:	Tooling: SPC (Y/N):			ate:		R	Run Start Stop	!/	R1* R2*	
Sequence ID/ Work Center II 120	)	Operation Description QC2- Inspect parts off ma	ochine FAI/FAIR	Set Up/ Run Hours	Т	ool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
*120* QC Quality Control		Memo	iennie i Abri Au	0.00	Ofe	ZØ13~0	7-24		<del>3</del> 0	4			
130		QC8- Inspect parts - seco	nd check	0.00						Л			
*130* QC Quality Control		Memo		0.00	P	P 13.	7.2	7	20	#			_

160

Identify as per dwg & Stock Location: WHO 4 '0.00

\*160\*
Packaging

Packaging

Memo

0.00

DQA:		Date:			WORK ORDER NON	c	ANIE (A	DNAANICE / 111	DDATE					DART
QA Closed:		Date:			WORK ORDER NON		JINFU	KIVIAINCE / UI		Wo	ork Order up	date only		AEROSPACE
Work Orde	ar.				DISPOSITION				AGAINST	DE	PARTMENT,	/PROCESS		
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Part N	lo.				Scrap	1		Machining	Small Fab		Pro	d. Eng. Coor.	-	Quality
					Use-as-is	1	1	noforming	Finishing			e/Packaging	-	Other
NCR N	lo				Suspected Unapproved	]		Large Fab	Composite	-		Supplier	-	
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Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descr	ription		Date	Verificatio	n	QC Inspector
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2011011	Bendin	σ			Bend		]Folio/F	Program	!		Outside Dim	ancione	Г	Pressure/Forced
		Not Conce	ntric		BOM/Route	$\vdash$	Grain	10810111		<u> </u>	Over/Under		_	Set-up
	Cracks				Broken/Damage/Defect	$\vdash$	Hardwa	ire			Part Incorred		H	Temperature/Cure
		Kink/Ripple	e/Wave		Burrs		4	c ion Incomplete/Ur	ngualified	<b>-</b>	Part Lost/Mi			Weld
	Cuffs	, ,,	•		Contamination		1	ions Incomplete/U	•		Part Moved	6	-	Wrong Stock Pulled
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	Heat Ti				Cut Too Short		Mislabe		·	$\vdash$	Power Loss/	•		Other
		ion Strip in	1 Tube		Drawing		Misrea			<b></b>	1 -7	Ū		
		Chatter Charter			Drill Holes		Off-set							
	Turnin	g Sequence	<u>:</u>		Finish		-1	Calibration						
	Wave	- Twist in Tul	he		Fit/Function		-{	Saguanca						

Work Orde		)4365		*104	1365*						Page 3
Item ID:	D4016-3			Accept	*N900	<b>040</b>	100*	Setu	p Start	*N.S	31*
Revision ID: Item Name:	Hinge Half, I	Lid							Stop	*N.S	32*
Start Date:	7/09/13	Start Qty: 20.00	*20*		Cust Item I	D:					
Required Date:	7/09/13	Req'd Qty: 20.00	*20*		<b>Customer:</b>						
Reference:			7 (7								
Approvals:	Process Pl	an:	Date:	Tooling:	Da	ate:	***	Run		*NF	<b>२1</b> *
	QC:		Date:	<b>SPC (Y/N):</b>	Da	ate:			Stop	*NF	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan A Code Q	-	. •	-	Insp. Stamp
170		QC21- Final Inspection -	Work Order Release	0.00					m/a	1-0-	10
*170*								1	1717	1240	3+

0.00

Memo

Quality Control

W 13.04-26

DQA:			Date:						_					•	TQAR <sup>®</sup>
OA Classel			Data			WORK ORDER NON-	-CC	ONFO	RMANCE / U		14/~~	l. Ordon	data anlı. C	_	AEROSPACE
QA Closed:			Date:				_			···	vvor	k Order up	date only		<u> </u>
Work Orde	er:					DISPOSITION				AGAINST [	DEP	ARTMENT	PROCESS		
	-					Rework			Skid-tube	Crosstube			Water Jet		Engineering
Part N	lo.					Scrap			Machining	Small Fab	$\dashv$	Proc	d. Eng. Coor.	╗	Quality
	•					Use-as-is		Thern	noforming	Finishing		Rec/Stor	e/Packaging	٦	Other
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Root	İ	5 .	<u>.</u>	۵.	Desci	ription of work order update		nitial		tion		Sign &			
Cause		Date	Step	Qty		or non-conformance	Cn	ief Eng	Desci	ription	+	Date	Verification	$\dashv$	QC Inspector
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		Centre No	ot Concer	ntric		BOM/Route		Grain				ver/Under	tolerance	_	Set-up
	$\vdash$	Cracks			<u> </u>	Broken/Damage/Defect		Hardwa	re	1		art Incorrec	<b> </b>	╝	Temperature/Cure
	$\vdash$	Crimp/Kir	rk/Ripple	/Wave		Burrs	<u> </u>	Inspect	on Incomplete/U	nqualified	P	art Lost/Mi	ssing	_ `	Weld
	-	Cuffs			<u> </u>	Contamination	<u> </u>	ł	ions Incomplete/	Unclear		art Moved			Wrong Stock Pulled
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	$\vdash \vdash \vdash$	Inspection	٠.	Tube	<u> </u>	Drawing		Misread	i		_				
	dash	Marks/Ch			<u> </u>	Drill Holes	-	Off-set			_				
	$\vdash$	Turning S			-	Finish	<u> </u>	4	Calibration						
		Wave/Tw	ist in Tub	oe		Fit/Function		Out of 9	Sequence						

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

**Picklist Print**July-09-13 12:50:42 PM

Work Order ID:

104365

Parent Item:

D4016-3

Parent Item Name:

Hinge Half, Lid

**Start Date:** 7/09/13

Required Date: 7/09/13

**Start Qty: 20.00** 

Required Qty: 20.00

Comments:

ISPP REV:A NEW ISSUE 09-11-27 JL VERIFIED BY:DD

IPP Rev:B as per dwg REV.A DD

•	
10.02.22	verified by:EC

	10.02.22 Vernicu	by.LC											
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B1.000X1.000 304 bar 1.00 x 1.00		Purchased	No			100	f	14.7000	0.08	1.68421	المد	13-7-2	10
				Location		Loc Oty	Lo	c Code					
				MAT050		14.7							
				125	5340	2.6			_				
				MI	26097	12.1			1.4				

DQA:	·	_ Date:						<b>_</b>					•	TABRT
QA Closed:		Date:			WORK ORDER NON	-CC	ONFO	RMANCE / U	PDATE	W	ork Order up	odate only	$\neg$	AEROSPACE
<u> </u>		· · · · · · · · · · · · · · · · · · ·			DISPOSITION				AGAINST	-	PARTMENT			
Work Orde	er:					,			AGAIIIST		, A	, i wocess		_
					Rework			Skid-tube	Crosstube			Water Jet		Engineering
Part N	10				Scrap			Machining	Small Fab		4	d. Eng. Coor.		Quality
					Use-as-is		Thern	noforming	Finishing	_	Rec/Stor	re/Packaging	_	Other
NCR N	10				Suspected Unapproved	]		Large Fab	Composite		]	Supplier		
Root		T		Desc	ription of work order update		nitial	Act	tion		Sign &		T	
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Desci	ription		Date	Verification	ı	QC Inspector
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Doc/Data											·		ļ	
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Training					•									
Transport														
Unapproved		<u> </u>				<u> </u>								
						FA	ULT CAT	regory						
Landi	ng Gear				General		1				7	-	_	
	Bending			<u> </u>	Bend	ļ	1	rogram		_	Outside Dim	· · · · · · · · · · · · · · · · · · ·		Pressure/Forced
		lot Conce	ntric	-	BOM/Route		Grain			<u> </u>	Over/Under	ļ-		Set-up
	Cracks			<u> </u>	Broken/Damage/Defect		Hardwa			_	Part Incorred	<b>}</b>	_	Temperature/Cure
		ink/Ripple	e/Wave		Burrs	<u> </u>	1	ion Incomplete/Ui	•	_	Part Lost/Mi	ssing	-	Weld
	Cuffs			-	Contamination	-	4	ions Incomplete/U	Jnclear	-	Part Moved	l		Wrong Stock Pulled
	Crushing			<u> </u>	Countersink		1	ned/off center		<u> </u>	Positioned V	· · ·		
	Heat Tre			-	Cut Too Short	ļ	Mislabe	•			Power Loss/	Surge		Other
		on Strip in	fube	-	Drawing	<u> </u>	Misread							
	Marks/C			-	Drill Holes	$\vdash$	Off-set							
		Sequence		-	Finish Fit/Function	<u></u>	4	Calibration						
	: IWave/Tu	MIST IN FII	ne		i Fit / Filinction	1	I Out of 9	Soguenco						

DART AEROSPACE LTD	Work Order:	104365
Description: Hinge Half, Lid	Part Number:	D4016-3
Inspection Dwg: D4016 Rev: A		Page 1 of 1

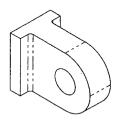
## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.88	+/-0.030	0.877			Calipy	OFC-01
0.13	+/-0.030	0.127	~		e,	V t
0.250	+/-0.010	0.249	~		V	4
R0.03	+/-0.030	ROU3D	1		Rudb	OFC
0.13	+/-0.030	0.127	V		Calipa	Oftol
0.50	+/-0.030	0.1499	V		4	V.
0.63	+/-0.030	0-6275	<b>/</b>		Ч	4
0.563	+/-0.010	0-561			Ч	Ч
Ø0.257	+0.006/-0.001	0,258	<u>し</u>		м	n
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Measured by: TPC	Audited by:	Preliminary Approval:
Date: 2018-07-29	Date: 3.7.24	Date:

Rev	Date	Change	Revised by	Approved
Α	10.06.07	New Issue	KJ 🛠 🕽	1

D4016-1 HINGE HALF, BASE



**D4016-3 HINGE HALF, LID** 

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED SUBJECT TO AMENI WITHOUT NOTI

WORK ORD.
10-4365 MC3
13-07-11

D4016-5 HINGE HALF, LIGHT LID

Α	NEWISS	WISSUE			10.01.29		
REV.			DESCRIPTION	BY	DATE		
DESIG	N	AJS	DART AEROSPACE LTD				
DRAW	N	AJS	HAWKESBURY, ONTARIO, CANADA		_		
CHECH	ŒD	a	DRAWING NO.		REV. A		
MFG. A	PPR.	Z	7 D4016		SHEET 1 OF		
APPROVED , DE APPR.		140	TITLE		SCALE		
		4	BASKET HINGE		NTS		
DATE 10.01.29			COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS IMPLATE AND CONFIDENTIAL AND IS BUPPLED ON THE EARRESS CONDITION THAT IT IS ROT TO BE UTED FOR ANY PROPECT OR CONFIDENCE TO TO MAY OTHER PERSON WITHOUT				

0.875 0.25 0.38+0.03 R0.38 Ø0.257 REF THRU GRAIN 0.88 DIRECTION 0.50 0.13 R0.03 TYP 0.75

**D4016-1 HINGE HALF, BASE** 

D4016-3 HINGE HALF, LID **D4016-5 HINGE HALF, LIGHT LID** 

3

0.13

0.250

R0.31 REF

> Ø0.257 THRU

GRAIN DIRECTION - 0.88

R0.03

--- 0.563 ---

0.50

0.13

0.63

DESIGN AJS DART AEROSPACE LTD DRAWN AJS HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. A D4016 MFG. APPR. SHEET 2 OF 2 APPROVED TITLE SCALE DE APPR. **BASKET HINGE** NTS DATE COPYRIGHT © 2010 BY DART AEROSPACE LTD
THIS DOCUMENT IN PRINTE AND CONFIDENTIAL AND IS SUPPLIED ON THE ELPHESS CONDITION TO BE USED FOR ANY PURPOSE ON COMMUNICATED TO ANY OTHER PERD
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THE BE USED FOR 10.01.29

NOTES: 1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M304B

-5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR, PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221 REF DART SPEC M6061T6B

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT -1: 0.09 ibs
-3: 0.04 lbs

8

-5: 0.01 lbs